

Part of

Work Order ID 69653

Monday, May 16, 2011 8:55:06 AM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 5/16/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/19/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan: *N*

Date: *11-05-16*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	Rev F3

120		0.00
	FLOW WATER JET	
Waterjet	Memo	0.00
FLOW CNC Waterjet	Cut Blank as per D2432 File	

B11-5-20

Pho →
Last Page

(16)

130		0.00
	HAAS CNC VERTICAL MACHINING #1	
HAAS 1	Memo	0.00
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr	

YK/20 11-9-13

140		0.00
	QC2- Inspect parts off machine FAI/FAIB	
QC	Memo	0.00
Quality Control		

YK/20 11-9-13

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC8- Inspect parts - second check

0.00

JL 11-09-14



QC

Memo

0.00

(15)

Quality Control

151

Identify as per dwg & Stock Location: _____ 0.00



Packaging

Memo

P1117274/11048
1x stock

0.00

Packaging

P 11/12/15 (10)

190

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/9/16 JF

MF 11-09-15

Picklist Print

Monday, May 16, 2011 8:55:12 AM

Page 1

Work Order ID: 69653



Parent Item: D2432



Parent Item Name: 206 (24") Bearpaw



Start Date: 5/16/2011

Required Date: 5/19/2011

Start Qty: 16.00

Required Qty: 16.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	78.6000	3.7	59.2			
UHMW 1" Black													

1811-5-20

Location Loc Qty Loc Code

MAT018 78.6

116554 2

117321 76.6

11738

117738

DART AEROSPACE LTD		Work Order: 69653
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.055	/		R-S	
B	5.500	+/-0.030	5.501	/		R-S	
C	0.200	+/-0.030	.194	/		A/C	
D	0.25 x 45°	+/-0.030	.265	/			
E	R0.250	+/-0.030	.250	/			
F	0.250	+/-0.010	.247	/			
G	0.625	+/-0.030	.635	/			
H	0.375	+/-0.010	.375	/			
I	0.950	+0.030/0.010	.957	/			
J	19.000	+/-0.030	19.010	/			
K	3.14	+/-0.030	3.130	/			
L	3.28	+/-0.030	3.2300	/			
M	Ø0.260	+0.005/-0.000	.260	/			
N	Ø0.93	+/-0.030	.923	/			
O	0.30	+0.030/-0.000	.301	/			
P	23.750	+/-0.030	23.745	/			
Q	7.375	+/-0.030	7.365	/			
R	4.250	+/-0.010	4.250	/			
S	2.000	+/-0.030	2.02	/			
T	9.000	+/-0.010	9.000	/			
U	9.000	+/-0.010	9.000	/			
V	0.375	+/-0.010	.379	/			

Measured by: R/K	Audited by: L	Prototype Approval: N/A
Date: 11-9-13	Date: 11-09-14	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

RELEASED
93.06.17 KA

SHOP COPY

RETURN TO

ENGINEERING

ROLLED COPY

TO AMENDMENT

OUT NOTICE

WORK ORDER

UN
S



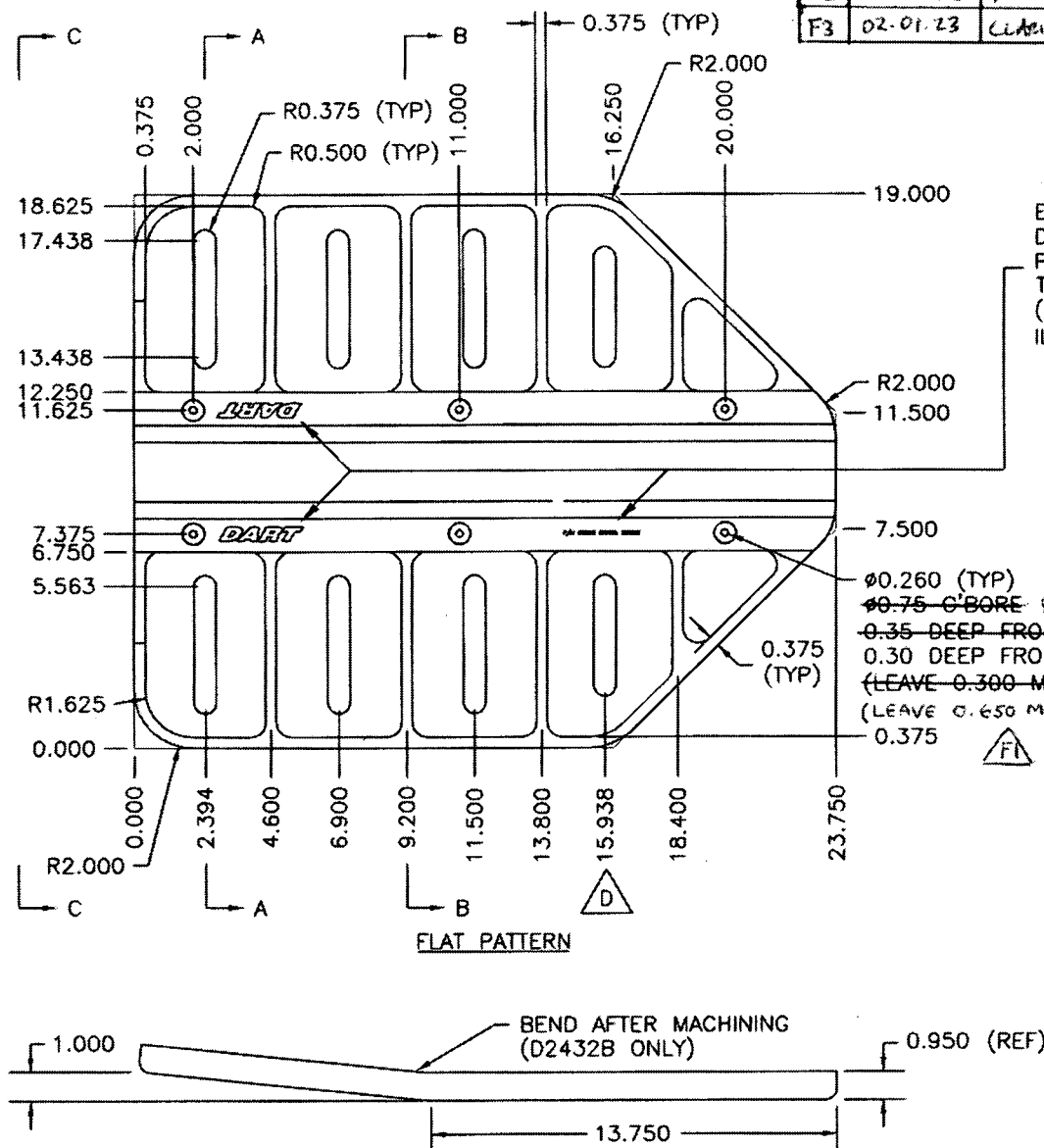
4453

11-05-16

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. F
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2432	SHEET 1 OF 2
DATE 98.05.12	TITLE BEARPAW	SCALE 1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

EFFECTIVE	DEOS
9143	



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

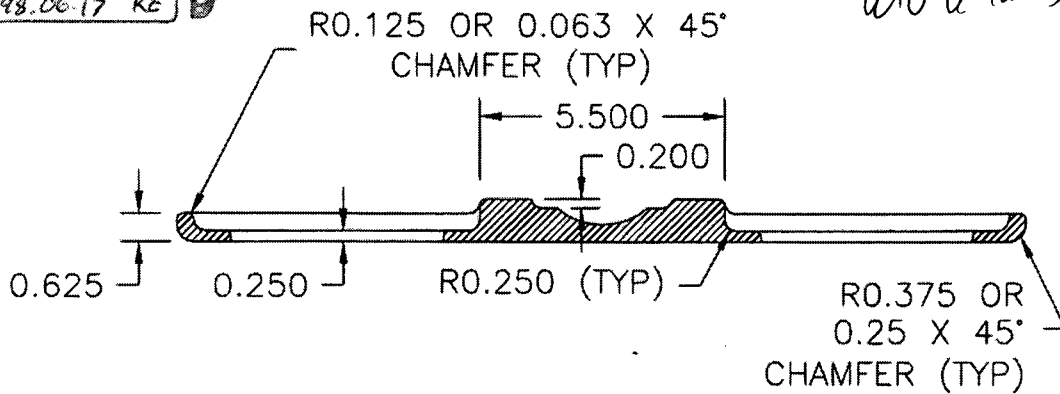
NOTE: Date & initial all entries



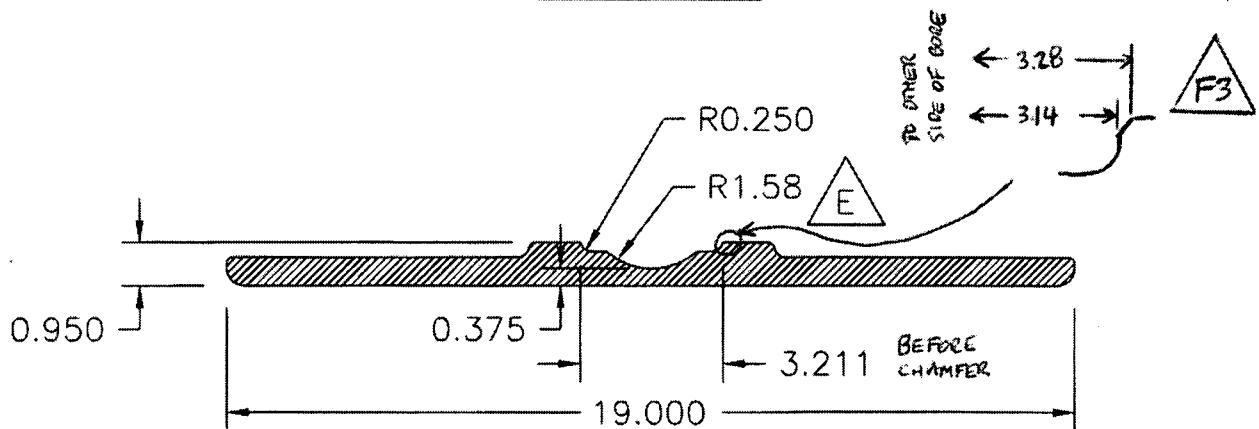
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

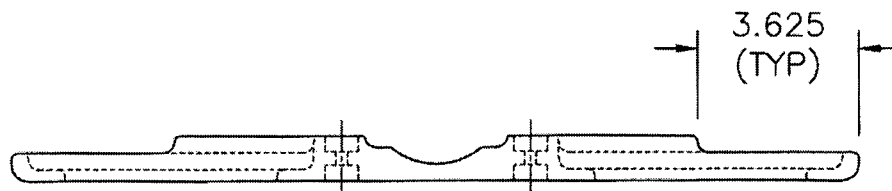
u10 69653



SECTION A-A



SECTION B-B



SECTION C-C

W/O: 69653		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2432 PAR #: _____ Fault Category: Small Part / water jet NCR: (Yes) No DQA: ✓ Date: 11/09/16
11-846 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/09/16

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 186.34						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-09-14	130	- 1 part was cut crooked on water jet leaving a big step in part, unable to machine part P.L. Process / water jet operator tries to fit the metal on sheet - process.	11-09-14 CS1012	- scrap no replace ah x1	11-09-14	5 11/09/14	11-09-14	11-09-14

NOTE: Date & initial all entries